

Date: Wednesday, 29/10/2008 10:11:31 AM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSY WELDMENT
Job Number	: 43062		
Estimate Number	: 13503		
P.O. Number	:	Part Number	: PB674300109
This Issue	: 29/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: B6743001 P.6
First Issue	: / /	Project Number	: N/A
Previous Run	: 42754	Drawing Revision	: B1
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 05/11/2008
Checked & Approved By	: <u>MF 08-10-30</u>	Qty:	1 Um: Each
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PB6743001211	Square Tubing
-----	--------------	---------------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Square Tubing
 batch:- 891487

MF 08-11-04

2.0	PB6743001209	Square Tubing
-----	--------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Square Tubing
 batch:- 343073

P608-11-19

3.0	PB6743001201	Square Tubing
-----	--------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Square Tubing
 batch:- 40592

MF 08-11-04

4.0	PB6743001203	Square Tube
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Square Tube
 batch:- 41789

MF 08-11-04

5.0	PB6743001239	Square Tube
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Square Tube
 batch:- 41917

MF 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 29/10/2008 10:11:31 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 43062

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Outer Tube

batch:- B41490

08/11/25

7.0

PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Outer Tube

batch:- B41489

08/11/25

8.0

PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Flanged Hook

batch:- 2400

mf 08-11-04

9.0

PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Restraint

batch:- 41211

mf 08-11-04

10.0

PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Contoured Hinge Arm

batch:- 41499

mf 08-11-04

11.0

PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle Arm Extension

batch:- 40044

mf 08-11-04

12.0

D34409

Tube Detent Clip Base (Supersedes B67-43)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Tube Detent Clip Base

batch:- 41205

mf 08-11-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

199 233

Date: Wednesday, 29/10/2008 10:11:31 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 43062

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket (Supersedes B67-43001-273)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

batch:- 41201

mf 08-11-04

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

08/11/25 ①

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08.11.26

BE 08/11/26

①x

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/26 ①

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11 = 10
320 OF
11 = 40

M-A 08/11/26

①x

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FZ 08/11/26 ①

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing

FZ 08/11/27 ①

Part No: B67-43001-09 PAR #: N/A Fault Category: Prod. LG. FAB NCR: Yes No DQA: NA Date: 08-11-28
Resolution: Re-work Disposition: Re-work QA: N/C Closed: NA Date: 08/11/27

[illegible]

H:\FORMS\Quality Assurance\approved QA\NCRW O RevE

Date: Wednesday, 29/10/2008 10:11:31 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 43062

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/28 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-11-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

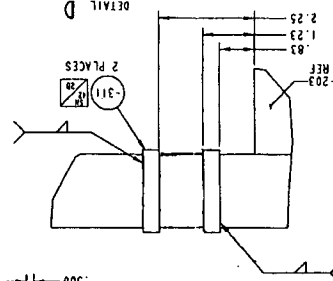
ORIGINAL

PREMIER AVIATION, INC.
3000 AVIATION PARKWAY, GRAND PRINCE, TEXAS 75052
D 05088 B67-43001 81

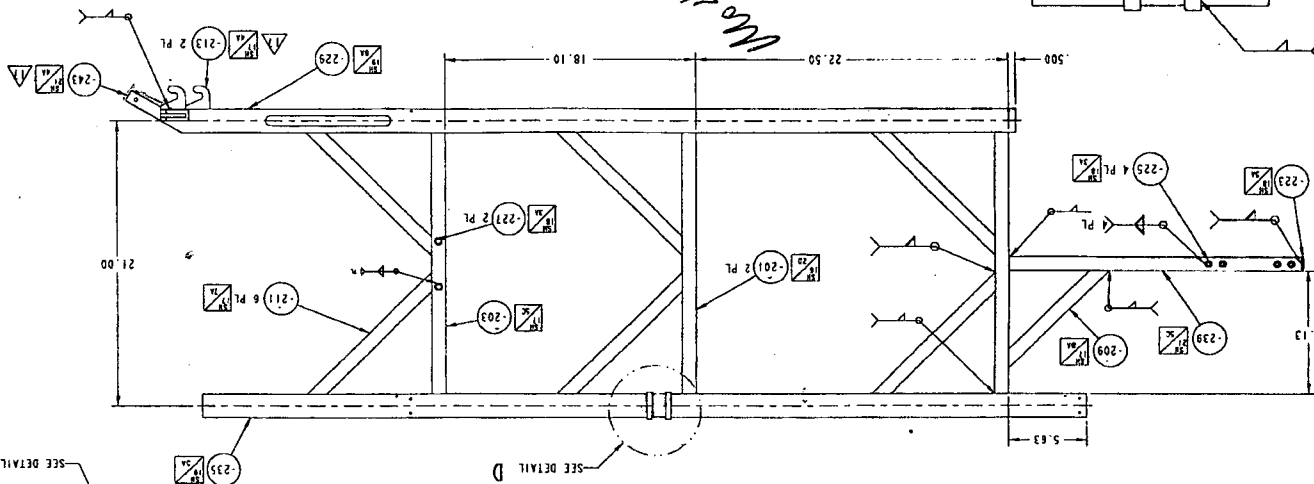
① -09 AFT BLADE FOLD ASSEMBLY WELDMENT

SCALE 0.250

DETAIL D
SCALE 0.150



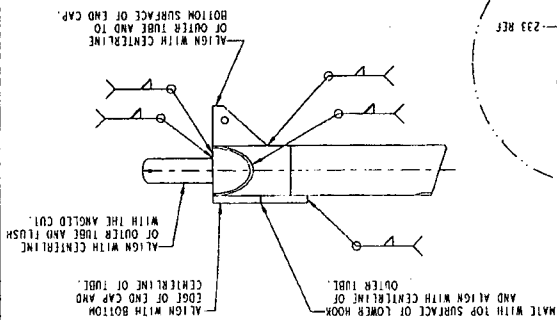
2904702



SEE DETAIL G

SEE DETAIL D

DETAIL G
SCALE 0.500



RELEASED
10-2-72